

5/46

DART AEROSPACE LTD	Work Order:	24686
Description: Bracket Assembly	Part Number:	D3155-041
DF 04.11.29		pB30-23000-11
Drawing: D3155 Rev A1C	Qty:	5
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	JA	05.10.26	5
2	MV	Cut blanks: (2.000" x 1.000") x 6.87" Long Bar Material: 6061-T6/-T651 (QQ-A-200/8 or QQ-A-225/8) (M6061T6B2.000x01.000) Batch: M18745	J.L	05.11.14	5
3	MV	Machine as per Folio FA315 and Dwg D3155	MB	05/12/12	5
4	QC2	Inspect parts as they come off the CNC machine	MB	05/12/12	5
5	MV	Deburr and Tumble	MB	05/12/12	5
6	QC5 & 8	Inspect work to Step 5	MB	05/12/12	5
7	FP	Chemical Conversion Coat per QSI 005 4.1	FE	05/12/14	5
8	QC3	Inspect Conversion Coat	FE	05.12.14	5
9	GA	Press fit bushing as per Dwg D3155 Qty Part number Description Batch 2 D3155-3 Bushing B24344	SB	05/12/15	5
10	QC5	Inspect work to Step 9	SB	05/12/15	5
11	ST	Identify and Stock Loc 402	PC	05/12/15	5
12	AC	Cost/part	SUR	05.12.2008	5
13	DC	Close W/O Inspect Level 21	PC	05/12/16	5



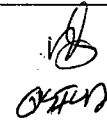
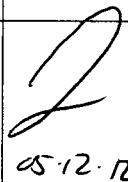
405
494

Rev	Date	Change	Revised By	Approved
A	02.05.30	New Issue	NG	
B	03.02.03	Reformat	KJ/RF RF	

RELEASED
03.02.04 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

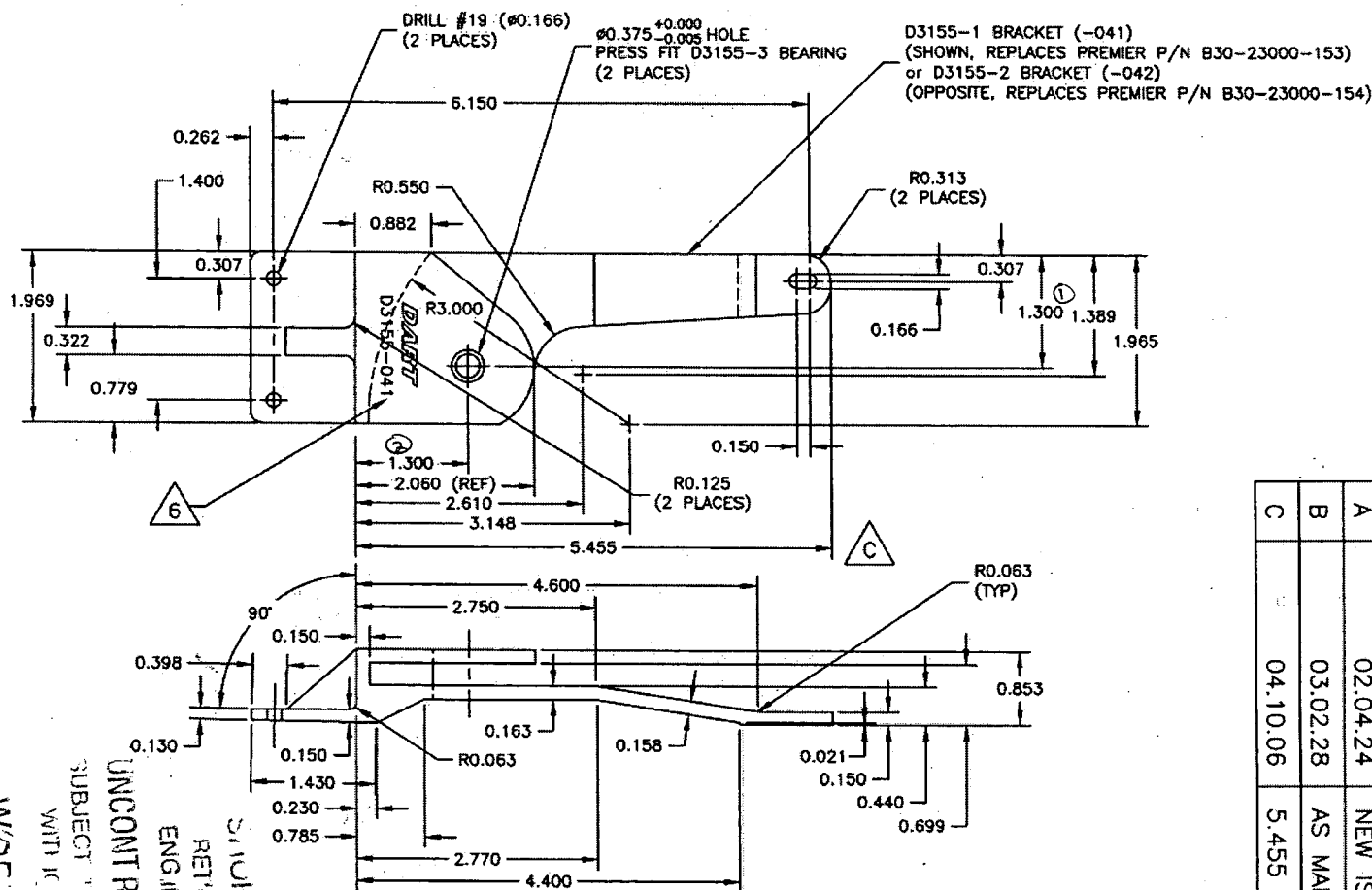
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 05/12/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05/12/12	4 th cp.	1 part moved in jig, causing floor to be machined too thin.	 05/12/12	Scrap replace, ensure part and jig are secure.	MS 05/12/12	 05/12/12		 05/12/12

NOTE: Date & initial all entries

GA COPIES ISSUED

DESIGN	UKRAIN B1	DARI AEROSPACE LTD		REV. C
		HAMKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.		SHEET 1 OF 2
04.10.06		D3155		SCALE
DATE		TITLE		
04.10.06		BRACKET ASSEMBLY		
A	02.04.24	NEW ISSUE		
B	03.02.28	AS MANUFACTURED		
C	04.10.06	5.455 WAS 5.550		



D3155-041 BRACKET ASSEMBLY

(SHOWN, REPLACES PREMIER P/N B30-23000-11)

D3155-042 BRACKET ASSEMBLY

(OPPOSITE, REPLACES PREMIER P/N B30-23000-12)

D3155-1/-2 BRACKET

- 1) MATERIAL: 6061-T6/-T651 (QQ-A-200/8 OR QQ-A-225/8) BAR
(REF DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO AS SHOWN

SAUB CO
RETURN TO
ENGINEER
UNCONTROL
SUBJECT
WITH IC
W/O
NN 246

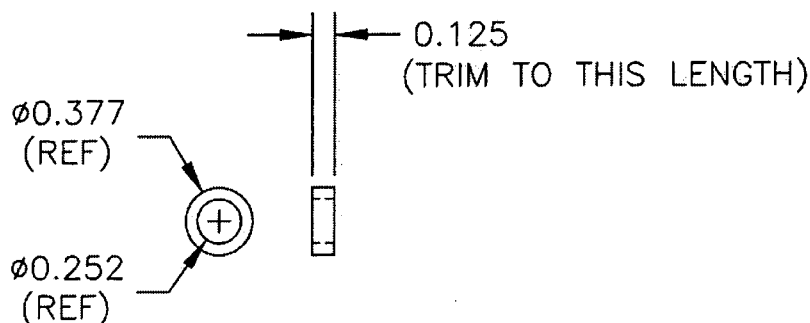
WOT
nn. 24686

04.11.23



DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3155	REV. C SHEET 2 OF 2
DATE 04.10.06		TITLE BRACKET ASSEMBLY	SCALE 1:1

RELEASED
04.11.23



D3155-3 BUSHING

- 1) MAKE FROM P/N SBS-3-3 (SOLID BAR) OR SS-812-20 (TUBING)
POSSIBLE SUPPLIER: SYMMCO
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SPRINT
RETURN TO
ENGINEERING

UNCONTROLLED
SUBJECT TO
WITHOUT

WORK OFF
NO 24686

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 25, 2005
04:04 pm

Work Order No : 0024686
Project Name : D3155-041
Project For : WK546
Work Order Type : Main
Main WO Number :
House Part Number : D3155-041
Description : Bracket Assembly
Manufactured : Yes
Amount Req'd : 5
Amount Done : 0
Start Date : 10-25-05
Est Finish Date : 11-15-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order:	24686
Description: Bracket assembly		Part Number:	D3155-1
Inspection Dwg:	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.166	±.010	Ø.166	✓			
Ø.375	+0.000 -0.005	Ø.375	✓			
6.150	±.010	6.148	✓			
R.313		R.3125	✓			
.307	±.010	.310	✓			
.166	±.010	.166	✓			
① 1.300	±.010	1.305	✓			
② 1.300	±.010	1.300	✓			
2.060	±.010	2.060	✓			
5.455	±.010	5.460	✓			
.779	±.010	.775	✓			
.322	±.010	.324	✓			
1.969	±.010	1.969	✓			
1.400	±.010	1.400	✓			
.307	±.010	.310	✓			
90°	±.010	90°	✓			
.130	±.010	.128	✓			
.150	±.010	.148	✓			
.163	±.010	.165	✓			
.853	±.010	.848	✓			
4.400	±.010	4.400	✓			
2.770	±.010	2.770	✓			

Measured by: M8	Audited by: J.L	Prototype Approval:
Date: 05/12/11	Date: 05.12.12	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	